

Rust

Dart Aerospace Ltd.

Date: Thursday, 06/11/2008 12:52:34 PM  
User: Chantal Lavoie

## Process Sheet

split

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : COVER  
Job Number : 43233  
Estimate Number : 12963  
P.O. Number :  
This Issue : 06/11/2008 S.O. No. :  
Prsht Rev. : NC Part Number : D36414  
First Issue : / / Type : SMALL / MED FAB Drawing Number : D3641 REV B  
Previous Run : 34544 Drawing Revision : B  
Written By : Due Date : 13/11/2008 Qty: 14 Um: Each  
Checked & Approved By :  
Comment : Est Rev:A New Issue 07-07-20 JLM Verified By:EC  
Est Rev:B ECN 1050 rev.b as per dwg 08-01-10 DD

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M6061T6S032 6061-T6 Sheet 0.032"



Comment: Qty.: 0.8244 sf(s)/Unit Total : 12.3653 sf(s) MAT NOT PULLED  
M6061-T6 .032" THK sheet  
Batch: 109396 B 8-11-7

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
1-Cut as per Dwg D3641  
Dwg Rev: B  
Prog Rev: B

B 8-11-7

2-Deburr if necessary B 8-11-7

(17)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

206-11-07 (17)

(PTO)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE  
Form as per Dwg D3641-1

Scrap

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D3641-4 PAR #: N/A Fault Category: PROD - sm. FAB NCR: Yes No DQA: Yes Date: 08.11.13  
0350-764-01A Resolution: Scrap Disposition: Scrap QA: N/C Closed: Yes Date: 08/11/20

NCR: <u>43233</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-11-07	20	Employee rolled 0.040" material by mistake. Material measures 0.039" → 0.037" after deburring. R.C. Did not measure the mat'l.	<i>[Signature]</i>	Acceptable this time only.  Parts are <del>not</del> no good. Cracked during bending. I.d mat'l as scrap, and use for band set ups. Material pulls i cracks in the off set die.	<i>[Signature]</i> 8-11-6 SB 08/11/12	<i>[Signature]</i> 08-11-07	<i>[Signature]</i> 08-11-07	<i>[Signature]</i> 08-11-07

NOTE: Date &amp; initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER

Job Number: 43233

Part Number: D36414

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Scrap

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: \_\_\_\_\_

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-11-12



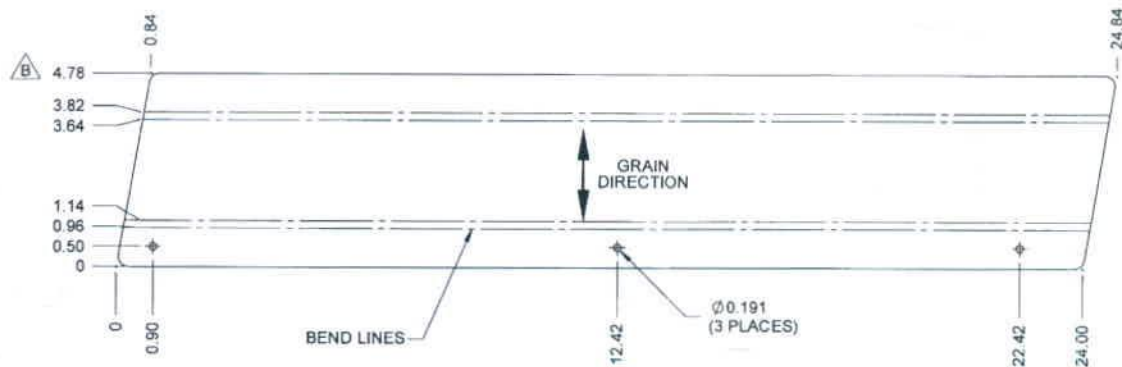
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

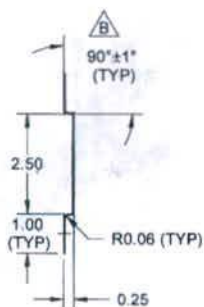
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3641-3F FLAT PATTERN**



W/O: 43233  
C/L 8111/06

**D3641-3 COVER**  
(REPLACES GENEVA P/N G10606-5)  
**D3641-4 OPPOSITE**  
(REPLACES GENEVA P/N G10606-4)

RELEASED  
07.11.14

- NOTES:**
- 1) MATERIAL: 5052-H32 ALUMINUM 0.032 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S 032)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-3/-4" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.36 lbs

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	LE	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. B
MFG APPR	TS	D3641	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR	MP	COVER	1:3
DATE	07.10.16	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL. NO PART OF THIS DOCUMENT IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	





